The listing of the claims will replace all prior versions and listings of claims in the application:

Listing of Claims:

- 1. (Currently Amended) Method for the production of a cooled ring insert—(1), consisting of a gray casting alloy having a nickel content, for an aluminum piston of an internal combustion engine, to be produced using the casting method, having a cooling channel (6)—formed on the ring insert back—(3), as a turned groove—(4) that is open towards the bottom, characterized by comprising the following steps:
- salt granulate is pressed into the turned groove—(4) at a pressure of 100 to 300 N/mm², so that a salt core—(5) is formed in the turned groove—(4);
- the combination consisting of the ring insert $\frac{(1)}{(1)}$ and the salt core $\frac{(5)}{(5)}$ is pre-heated to a temperature of 200°C to 250°C; and
- the combination consisting of the ring insert (1) and the salt core (5) is dipped into an alfin bath consisting of an aluminum melt.

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- 2. (Currently Amended) Method for the production of a cooled ring insert (1) as recited in claim 1, characterized in that wherein the combination consisting of the ring insert (1) and the salt core (5) combination is dipped into an alfin bath consisting of an aluminum melt for 2½ to 5½ minutes.
- 3. (Currently Amended) Method for the production of a cooled ring insert (1), consisting of a gray casting alloy having a nickel content, for an aluminum piston of an internal combustion engine, to be produced using the casting method, having a cooling channel formed on the ring insert back, as a turned groove that is open towards the bottom, comprising the following steps: as recited in claim 1 or 2, characterized in that
- __ a finished, pressed salt core (5)—is placed into the turned groove—(4), and attached in the turned groove—holder (4)—by means of an adhesive bond[[.]];
- <u>the combination consisting of the ring insert and the</u>
 salt core is pre-heated to a temperature of 200°C to 250°C; and
- <u>the combination consisting of the ring insert and the</u> <u>salt core is dipped into an alfin bath consisting of an aluminum</u> melt.